

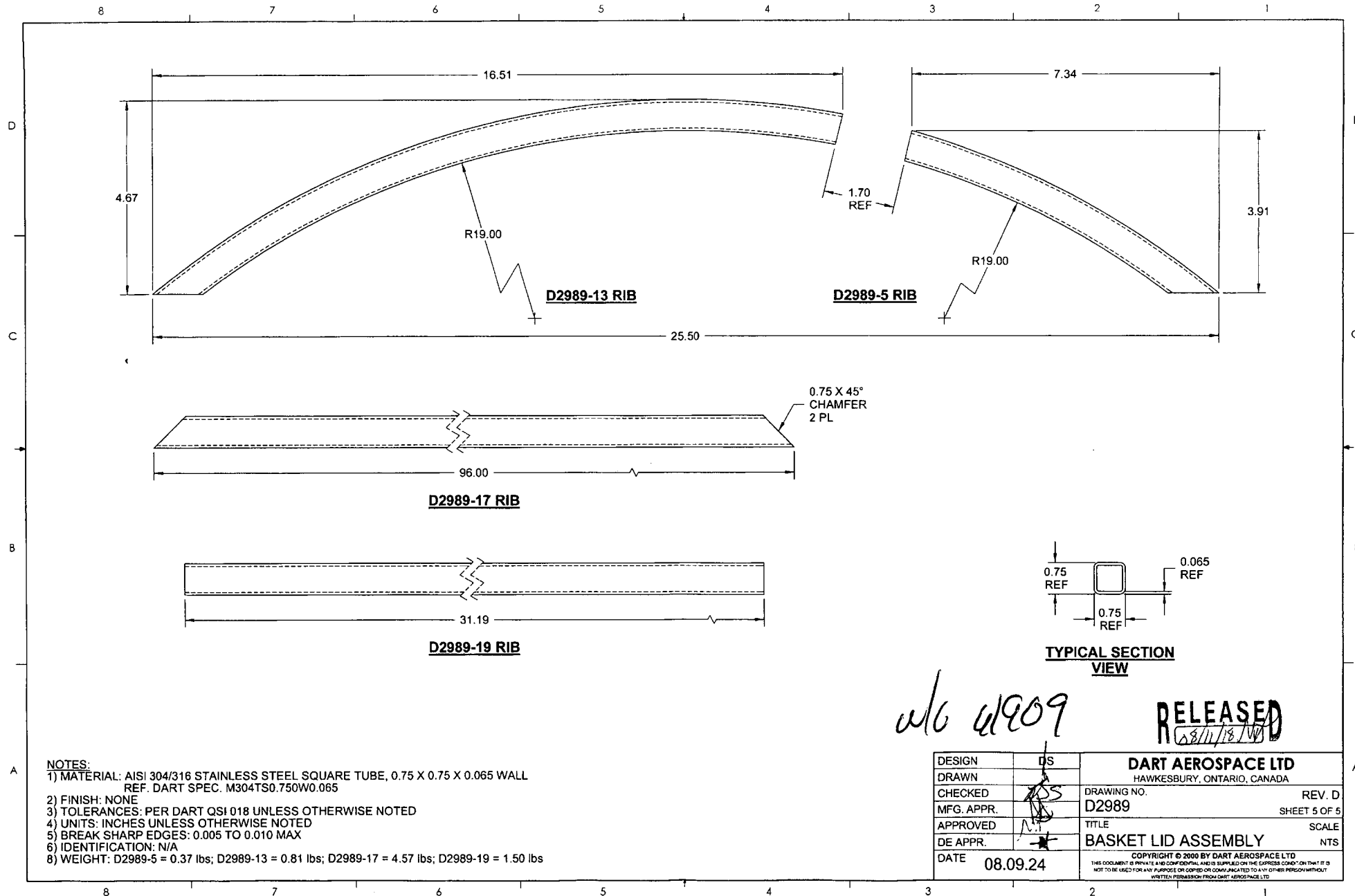
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 5 OF 5
APPROVED	NT	TITLE BASKET LID ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD	
DATE	08.09.24	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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08/11/18

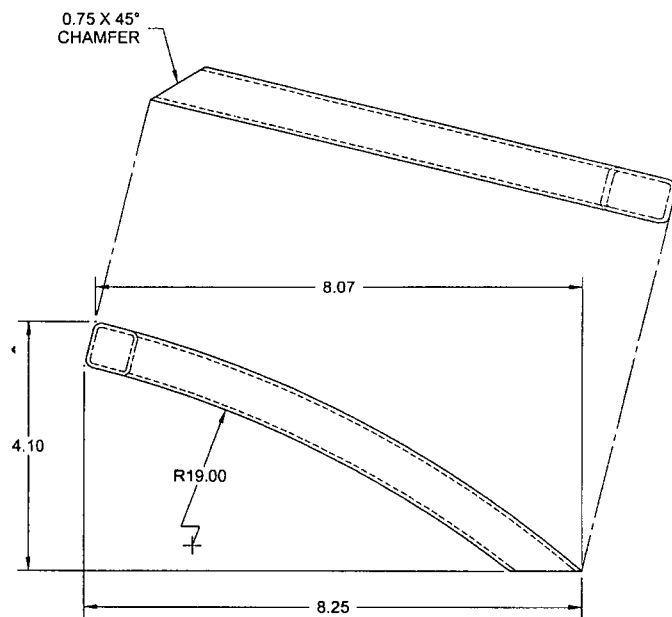
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

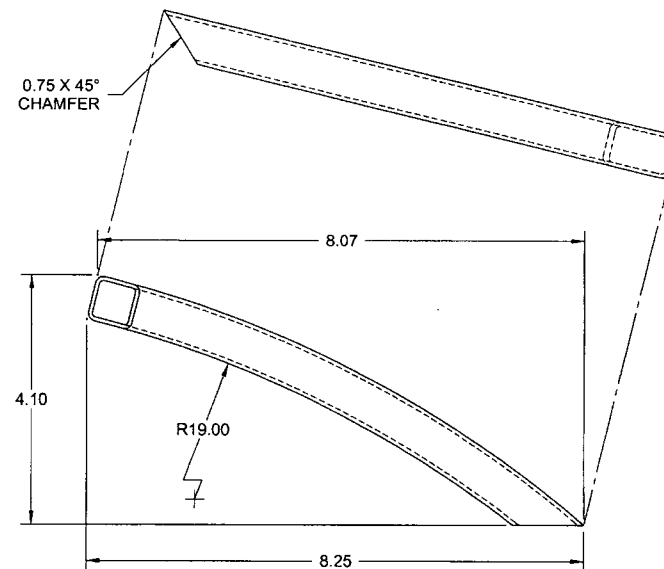
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

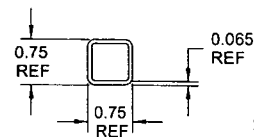
NOTE: Date & initial all entries



D2989-3 RIB



D2989-4 RIB



TYPICAL SECTION VIEW

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

w/c 01909

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

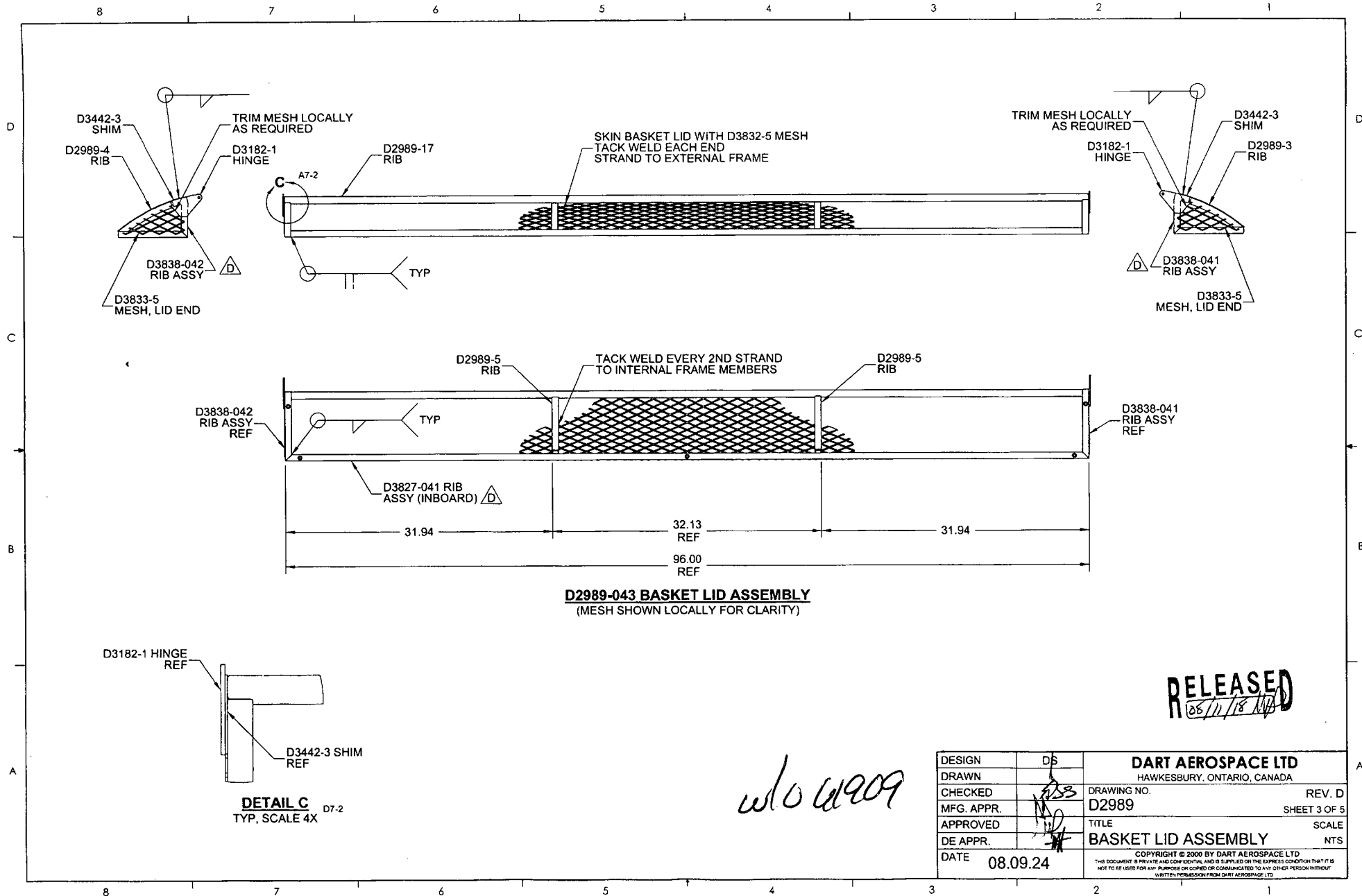
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

C

B

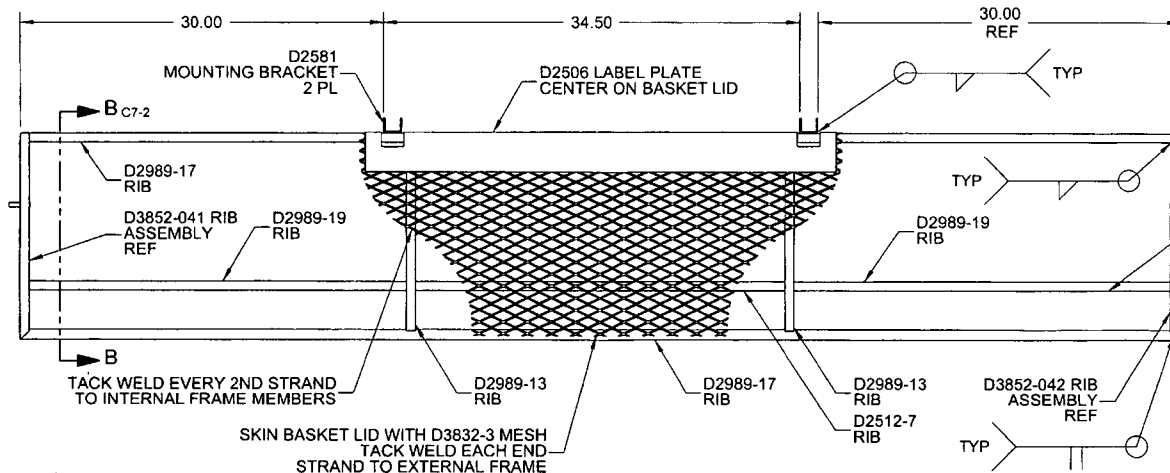
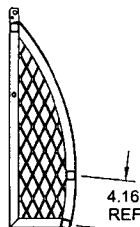
B

A

A

SECTION B-B

D7-2

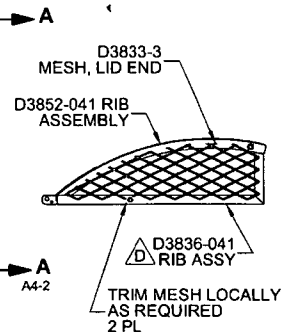


TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKID'D

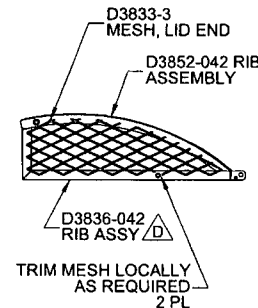
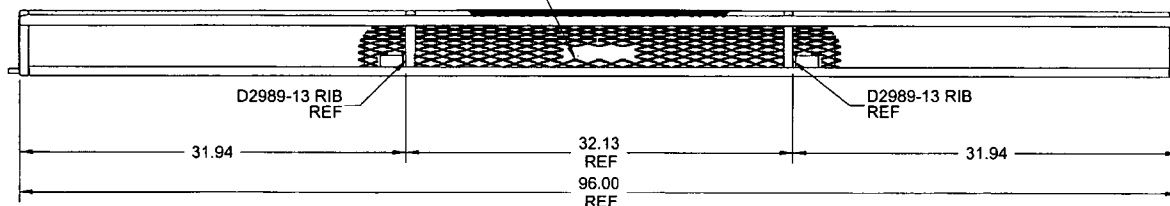
BLACK ANTI-SKID
PAINT THIS SECTION

SKIN BASKET LID WITH D3832-3 MESH
TACK WELD EACH END
STRAND TO EXTERNAL FRAME

TACK WELD EVERY 2ND STRAND
TO INTERNAL FRAME MEMBERS



TACK WELD MESH TO LABEL PLATE
AT EVERY AVAILABLE LOCATION



D2989-041 BASKET LID ASSEMBLY (MESH SHOWN LOCALLY FOR CLARITY)



2 PL
FILL NOTCH
WITH WELD
9 PL

VIEW A:A B8-2

WLO 61909

RELEASED
08/11/18/19

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	KS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

SHOP COPY
RETURNED
ENGINEERED
UNCONTINUED
SUBJECT TO A4111111

WITHIN THE
WORK ORDER
NO. 41909
BS10-9-09

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/12

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-12 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DS		
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.	DS	D2989	SHEET 1 OF 5
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

Thursday, September 09, 2010 1:15:01 PM

Work Order ID: 61909



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3838-042

Manufactured No

100

Each

0.0000

1

1



Rib Assembly (Basket Lid, RH)



361398 → ① Pl 10-10-14

Thursday, September 09, 2010 1:15:01 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 09, 2010 1:15:01 PM

Page 2

Work Order ID: 61909

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3442-3
Shim

Manufactured No

100 Each

4.0000

2 2

Location

Loc Qty

Loc Code

WA

4

61176

4

100 Each

5.0000

1

Location

Loc Qty

Loc Code

WA

5

61177

5

100 Each

2.0000

1

D3832-5
Mesh (Lid)

Manufactured No

100 Each

2.0000

1

Location

Loc Qty

Loc Code

WA

2

60671

2

100 Each

3.0000

2

D3833-5
Mesh (Lid End)

Manufactured No

100 Each

3.0000

2

Location

Loc Qty

Loc Code

WA

3

53722

1

60673

2

100 Each

0.0000

1

D3838-041
Rib Assembly (Basket Lid, LH)

Manufactured No

100 Each

0.0000

1

Thursday, September 09, 2010 1:15:01 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, September 09, 2010 1:15:01 PM

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 9/9/2010**Required Date:** 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61909

Page 4

Thursday, September 09, 2010 1:14:57 PM

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 9/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Identify as per dwg & Stock Location G-A

0.00

Memo

w/o 62891

0.00

Packaging

160



QC

QC21 - Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

MF
10-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61909

Thursday, September 09, 2010 1:14:57 PM



Page 3

Item ID:	D2989-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid Assembly					
Start Date:	9/9/2010	Start Qty:	1.00			
Required Date:	9/17/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes prior to powder coating								
	2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989								
	IST COAT								
	START TIME: 8:30								
	OVEN TEMPERATURE: 400°								
	FINISH TIME: 11:00								
	***** 2nd coat if necessary*****								
	2ND COAT:								
	START TIME:								
	OVEN TEMPERATURE:								
	FINISH TIME:								
140 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

BR 10-10-14

M 115291

①

9/10/10/18 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61909

Thursday, September 09, 2010 1:14:57 PM



Page 2

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 9/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

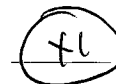
QC6- Inspect dimensions to drawing

0.00

Memo

0.00

5/10/10/14



125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

=) 10/10/14

1 d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 61909

Thursday, September 09, 2010 1:14:57 PM



Page 1

Item ID:	D2989-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid Assembly					
Start Date:	9/9/2010	Start Qty:	1.00			
Required Date:	9/17/2010	Req'd Qty:	1.00			
Reference:						
Cust Item ID:						
Customer:						

Approvals:	Process Plan:		Date:	10-9-09	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2989	Rev D								

100		0.00							
	Large Fab								
Large Fab									
Large Fab	Memo	0.00							
	1- assemble all ribs in DT9446 jig, weld as per dwg D2989								
	2- tack weld mesh on basket as per dwg D2989 using DT9446 jig								
	3- to locate hinges and shims use D2989-041, weld as per dwg D2989								
	A/R ER316 S.S. Rod Batch: 111585								

10.10.14

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

PD 10.10.14